

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DOOR ASSEMBLY	
Job Number	: 41797-2			Part Number	: D3296041	
Estimate Number	: 11403			Drawing Number	: D3296 REV A	
P.O. Number	:			Project Number	: N/A	
This Issue	: 04/09/2008 S.O. No. :			Drawing Revision	: A	
Prsht Rev.	: NC			Material	:	
First Issue	: / / Type : SMALL / MED FAB			Due Date	: 11/09/2008	
Previous Run	: 39871			Qty:	4 Um: Each	
Written By	:			4		
Checked & Approved By	: JUO 089.04					
Comment	: Est. C 05.10.14 Added step 14 KJ/EC					
	: Est Rev:D Revised Steps 06-11-20 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D32961	Door Panel			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)					
Door Panel					
Pick:					
Qty	Part Number	Description	Batch		
1	D3296-1	Door Panel	39744		
AS 08/09/04 (12)					
2.0	D32963	Door Panel			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)					
Door Panel					
Pick:					
Qty	Part Number	Description	Batch		
1	D3296-3	Door Panel	35233x2 39745x10	AS 08/09/04 (12)	
AS 08/09/04 (12)					
3.0	D31617	Hinge 14.0"			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)					
Hinge 14"					
Batch: B39891x10					
AS 08/09/04 (12)					
4.0	D31619	Hinge 17.0"			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)					
Hinge 17"					
Batch: B31683					
AS 08/09/04 (12)					

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Drawing Name: DOOR ASSEMBLY

Number: 41797

Part Number: D3296041

Number:



Seq. #: Machine Or Operation:

Description:

5.0 MS20470AD44

Rivet, Universal Head

Comments: Comp want all tips



Comment: Qty.: 25.0000 Each(s)/Unit Total: 300.0000 Each(s)

Rivet, Universal Head

Batch:

MIG7823 x7

all same batch

AS 08/09/04 K2

6.0 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Fabricate &amp; assemble as per Dwg D3296.

FF 08/09/10

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



M 1 0 2 3 1 6

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005.4.3

START TIME: 10:46AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:10AM

91 08-09 - 10

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/09/10

10.0 D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Decal - No Step

Pick:

Qty	Part Number	Description	Batch
1	D2137	Decal	39139 x7 M108012 x5

UP 08/09/04 K2

11.0 D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Handle

Pick:

Qty	Part Number	Description	Batch
1	D2419	Handle	39881 x7

AS 08/09/04 K2

## Process Sheet

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Part Number: 41797

Part Number: D3296041

Number:



Seq. #: Machine Or Operation:

Description :

12.0 D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total: 3.9996 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 4.00" LONG



JS 08/09/04 RD

13.0 D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total: 5.3040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 5.30" LONG



JS 08/09/04 RD

14.0 D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total: 24.5040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 24.50" LONG



JS 08/09/04 RD

15.0 D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal



JS 08/09/04 RD

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer



JS 08/09/04 RD

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Job Number: 41797

Part Number: D3296041

Job Number:



Seq. #:	Machine Or Operation:	Description:
17.0	MS20470AD46	Rivet, Universal Head
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch 1 MS20470AD4-6 Rivet
18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3296
19.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
20.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>377</u>
21.0	QC21	FINAL INSPECTION/W/O RELEASE
		Comment: FINAL INSPECTION/W/O RELEASE

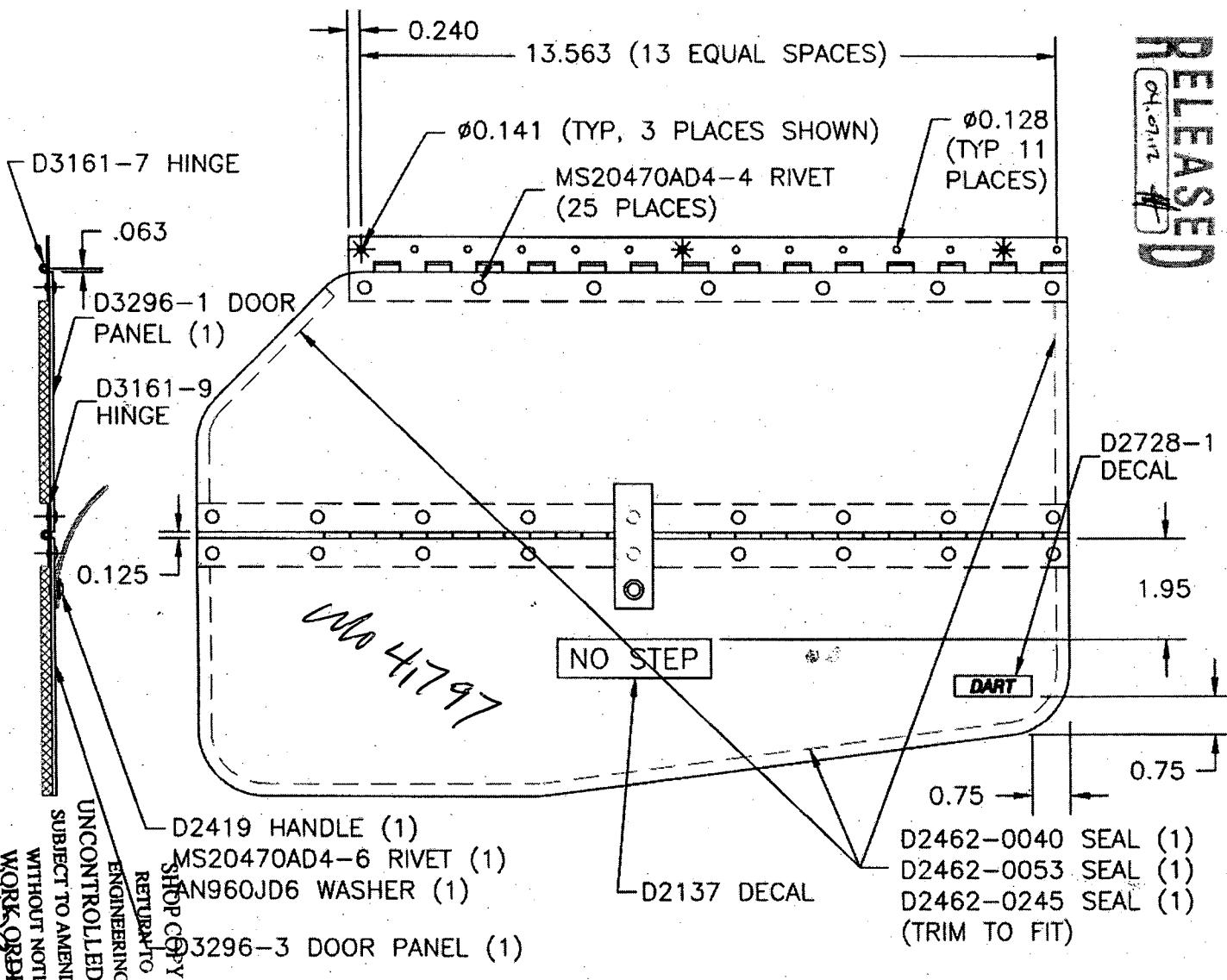
Job Completion



u 08/09/11

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3296
DATE		REV. A
04.06.28		1 OF 2
		SCALE
		1:3
A	04.06.28	NEW ISSUE

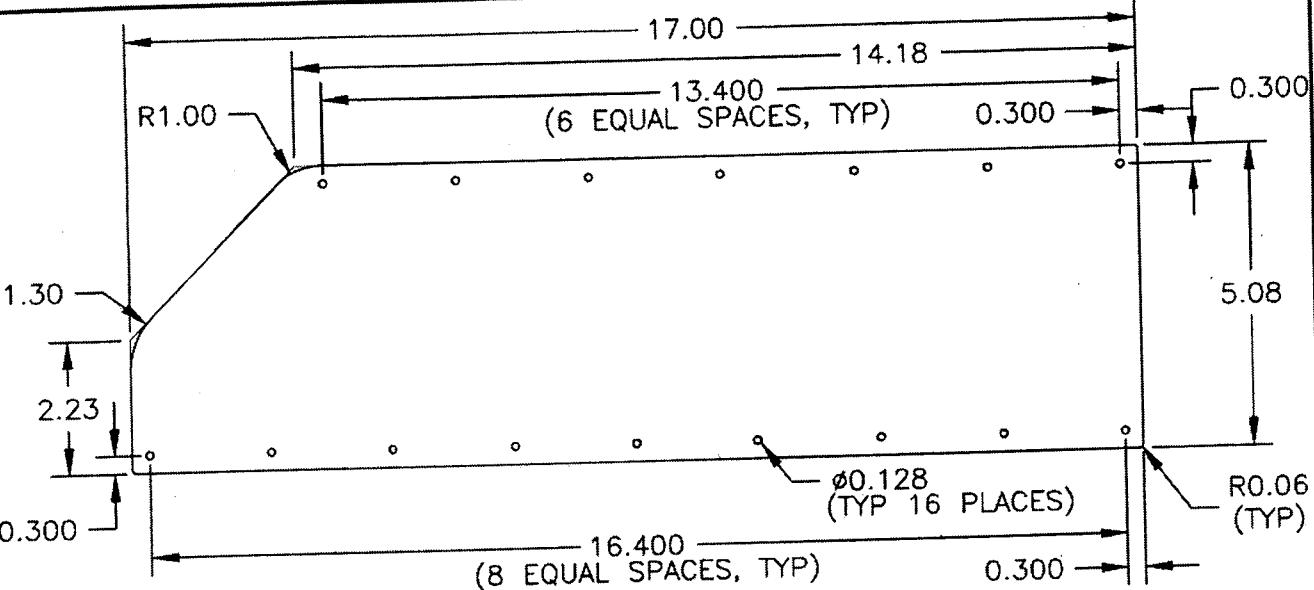
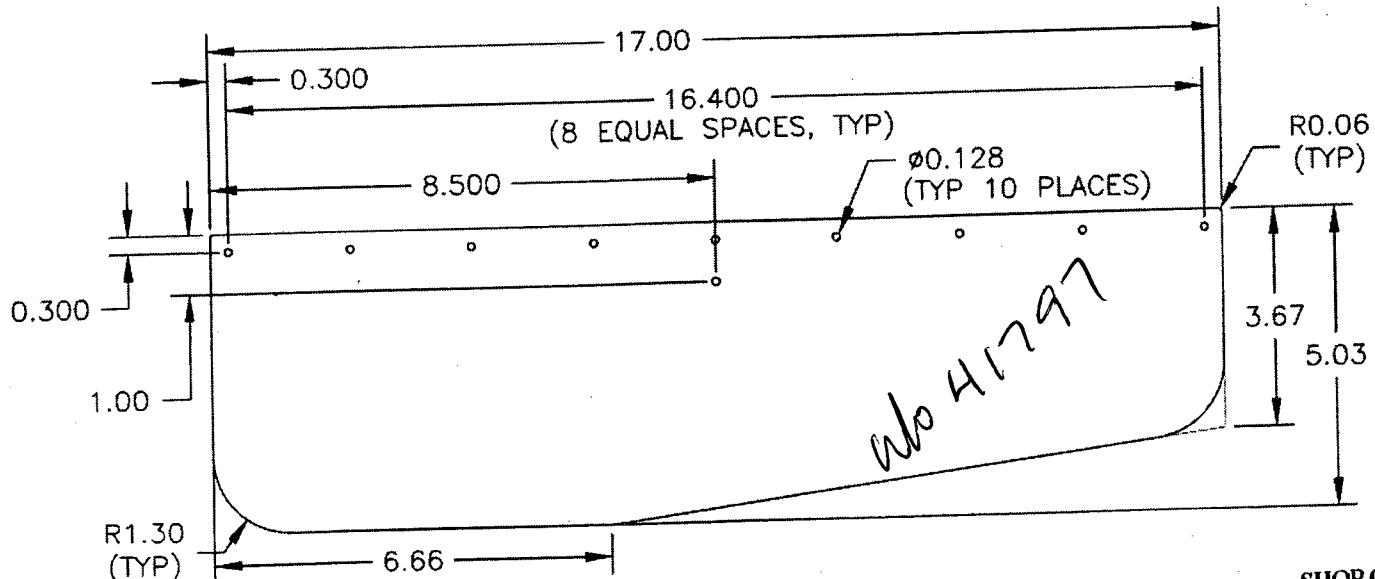
**RELEASED**  
04.07.12

UNCONTROLLED COPY  
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WORK ORDER NO. 041  
D3296-3 DOOR ASSEMBLY  
ENGINEERING  
RETURN TO  
SHOP COPY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**COPY  
SERIAL

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3296
DATE 04.06.28		REV. A 2 OF 2 TITLE DOOR ASSEMBLY SCALE 1:3

**D3296-1 DOOR PANEL****D3296-3 DOOR PANEL****D3296-1 AND D3296-3**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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